

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013306**Date Inspected:** 21-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Tu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 11, East Tower Lift 4 BC Corner Diagonal Plate (Green Tag No. 12049)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ESTL4-2B/L-16, 22 (From 131M Top to 143M Diaphragm)

ESTL4-2H/L-14, 69, 83, 84

ESTL4-2I/L-14, 15, 84, 85

ESTL4-2J/L-14, 15, 84, 132

ESTL4-2K/L-14, 15, 84, 85

This Quality Assurance (QA) Inspector observed the following work in progress:

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SOUTH TOWER LIFT 5, AE CORNER REPAIR

SMAW welding of weld joint 36A/B(Repair) located on SSD1-TL5-1B-F.

Welder IS identified as 052493. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-REPAIR-1.

SHEAR PLATE

SAW welding of weld joint 1B located on SSD1-A112A/H.

Welder IS identified as 0503060. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

NORTH TOWER LIFT 4, BC CORNER DIAGONAL PLATE

FCAW welding of weld joint 49 located on NSTL4-3B/L.

Welder IS identified as 053870. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F-2.

NORTH TOWER LIFT 4, CD CORNER DIAGONAL PLATE

FCAW welding of weld joint 20 located on NSTL4-3B/L.

Welder IS identified as 047350. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F-2.

BAY11

STRUT ANGLE CONNECTION PLATE

SMAW welding of weld joint 1A located on WD1-SA4-56-143M-1.

Welder is identified as 040614. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

STRUT FLANGE PLATE

SAW welding of weld joint 2B located on WD1-STSA4-5-135M-1.

Welder is identified as 044560. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

PHASED ARRAY ULTRASONIC TESTING (PAUT) TRAINING

This Quality Assurance (QA) Inspector attend the Phased Array Ultrasonic Testing (PAUT) training session organized by ASNT level III.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
